



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3537-11
Job Sheet 185970



Part No: D3537-11

Job Qty: 10 ea

Part Name: Wearpad



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/18

Job Tracking No:

Due Date: 11/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP REV:A 14.11.05 NEW ISSUE DD VERF:JFS IPP REV:B 15.10.16 AUTOMATED PROCESS
DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs	11/29/18	11/29/18	0.00	0.89	Waterjet - Flow		
110	QC	10 pcs	11/29/18	11/29/18	0.00	0.00	QC2 Waterjet-2		
120	QC	10 pcs	11/29/18	11/29/18	0.00	0.00	QC8-2		
130	Brake NC	10 pcs	11/29/18	11/29/18	0.18	0.56	Brake NC 1		
140	QC	10 pcs	11/29/18	11/29/18	0.00	0.00	QC5		
150	Autoweld 1	10 pcs	11/29/18	11/29/18	0.00	0.40	Automated welding		
160	QC	10 pcs	11/29/18	11/29/18	0.00	0.00	QC10		
170	QC	10 pcs	11/29/18	11/29/18	0.00	0.00	QC5		
180	HandFinish	10 pcs	11/29/18	11/29/18	0.00	0.37	HandFinish4		
190	QC	10 pcs	11/29/18	11/29/18	0.00	0.00	QC3		
200	Packaging	10 pcs	11/29/18	11/29/18	0.00	0.00	Packaging3-1		
210	QC21-SA	10 Ea	11/29/18	11/29/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.4900 sf (.149 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	139	0

Part Specifications

Specifications could not be found.

Plex 11/7/18 1:32 PM Dart.lajeunesse.marie

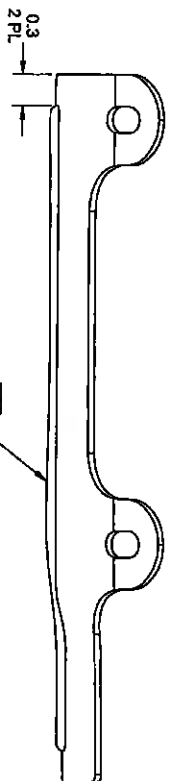
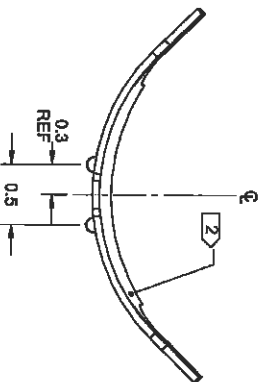
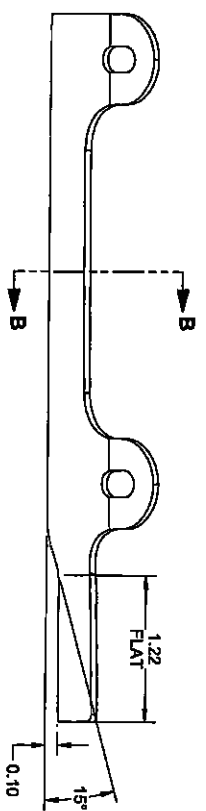
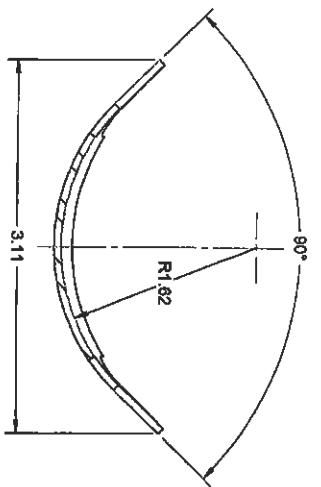
Entered: _____ Date: _____
NCR No. _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



Job: <u>D3537-11</u>		DISPOSITION		DEPARTMENT/PROCESS		Engineering									
Part No. <u>#185970</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: <u>JUL 25 2019</u>	Sequence #: <u>140</u>	QTY Affected: <u>140814</u>		MRB (QS1042)											
Description Work Order Deviation				Disposition				Completed By							
<u>- wrong bend in wearplate</u> <u>- opposite bend</u>				<u>- scrap wearplate</u>				Lead hand / Supervisor							
								<u>DAS 30</u> <u>JUL 24 2019</u> <u>9-89</u>							
Root Cause				FAULT CATEGORY											
				☐ Pressure/Forced ☒ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled				☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function				☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up			
☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors				Other/Details:											

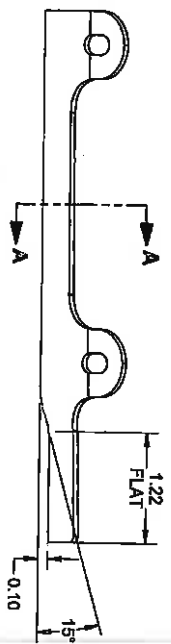
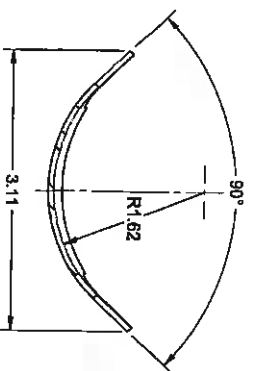


- NOTES:
- 1) MATERIAL: MAKE FROM .3F
 - 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.01 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 004 6.1
 - 7) WEIGHT: 0.25 lbs
 - 8) APPLY HARD SURFACING WELD BEAD 0.08 - 0.13 THICK USING 8228 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR 20598 ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

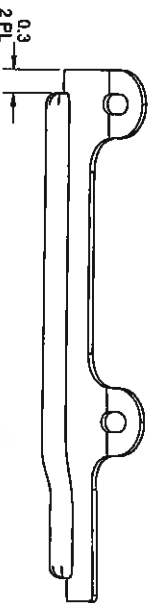
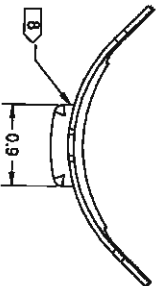
APPROVED

DESIGN	CB	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE, OR
CHECKED	DD	REV. F
MFG. APPR.	NO	D3637
DE APPR.	DS	WEARPAD
DATE	17.12.04	SCALE
		NTS

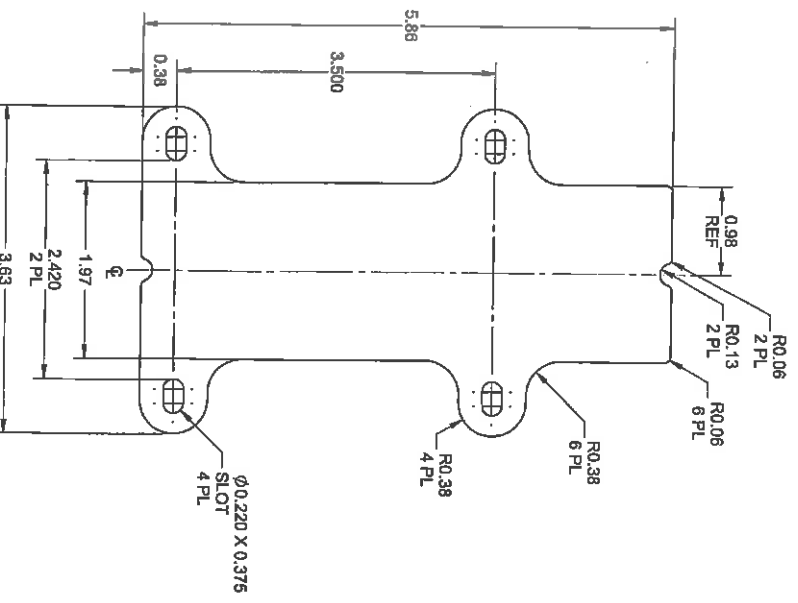
RELEASED
2000 OCT 19



D3537-3 WEARPAD
(BENDING DETAIL)
(MAKE FROM D3537-3F)



D3537-3 WEARPAD
(WELDMENT)



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 16 GAUGE 0.063 THICK
PER MIL-S-8059 OR AMS 5613 OR 5624 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S-16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.50 lbs
- 8) BUILDUP HARD SURFACING 0.17 - 0.20 THICK USING 825G ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.18 - 0.25 THICK USING 2089B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

RELEASED
2010 OCT 9

D3537-3F WEARPAD
(FLAT PATTERN)

APPROVED

DESIGN	CB	DART AEROSPACE USA, INC.
DRAWN	ZF	DRAWING NO.
CHECKED	ZF	EUGENE, OR
MFG. APPR.	DD	D3537
APPROVED	NO	TITLE
DATE	17.12.04	WEARPAD

COPYRIGHT © 2004 BY DART AEROSPACE USA, INC.
THIS DRAWING IS UNCLASSIFIED AND IS RELEASED TO THE PUBLIC DOMAIN
FOR THE INFORMATION OF THE USER. NO WARRANTY IS MADE BY DART AEROSPACE USA, INC.